

Date: Wednesday, 03/12/2008 7:03:11 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEARSHOE		
Job Number	: 43893			Part Number	: D35645		
Estimate Number	: 12786			Drawing Number	: D3564 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 03/12/2008	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 10/12/2008		
Previous Run	: 43408			Qty:	20	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC Est Rev D added DT# 08.04.21 DD Verified by EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 Sheet .063
		Comment: Qty.: 1.5750 sf(s)/Unit Total : 31.5000 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: 109057 HB 8-12-3
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: D HB 8-12-3 Prog Rev: D
		2-Deburr if necessary HB 8-12-3
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE HB 8-12-3
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK HB 8-12-3
		Comment: SECOND CHECK HB 8-12-3
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155

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Seq. #: Machine Or Operation:

Description :

Form Joggle as per Dwg D3564 on brake using Jig DT8157

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

E/B 08/12/08 (22)



Comments

S 08/12/08 X2L

7.0 POWDER COATING POWDER COATING



M 109 648



Q2X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 2 - 30

OVEN TEMPERATURE: 320 °F

FINISH TIME: 3 - 00

m-f 08/12/08

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-08 (22)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: I-P-19

mf 08-12-08 (22)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



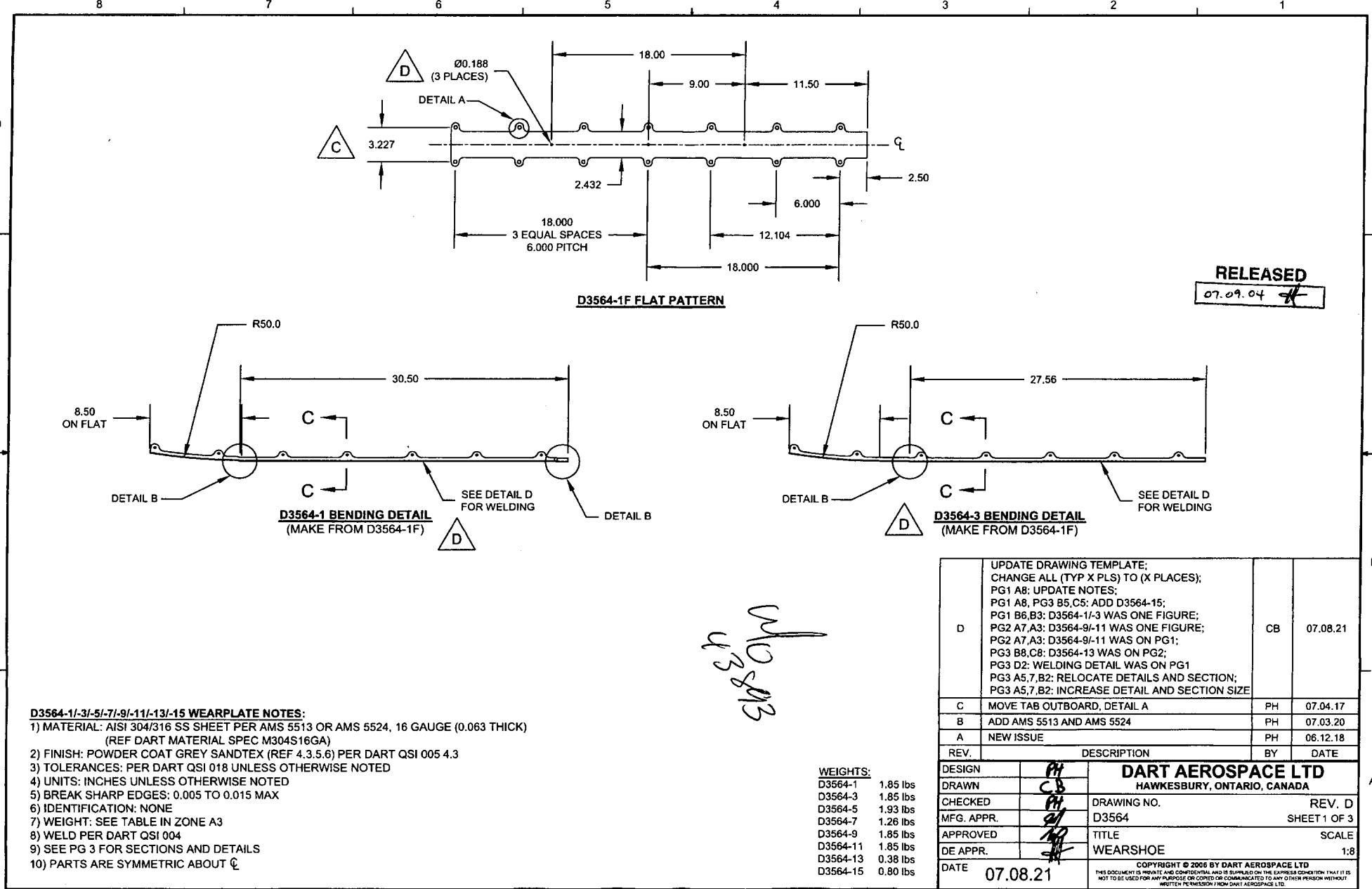
08/12/10 (22)

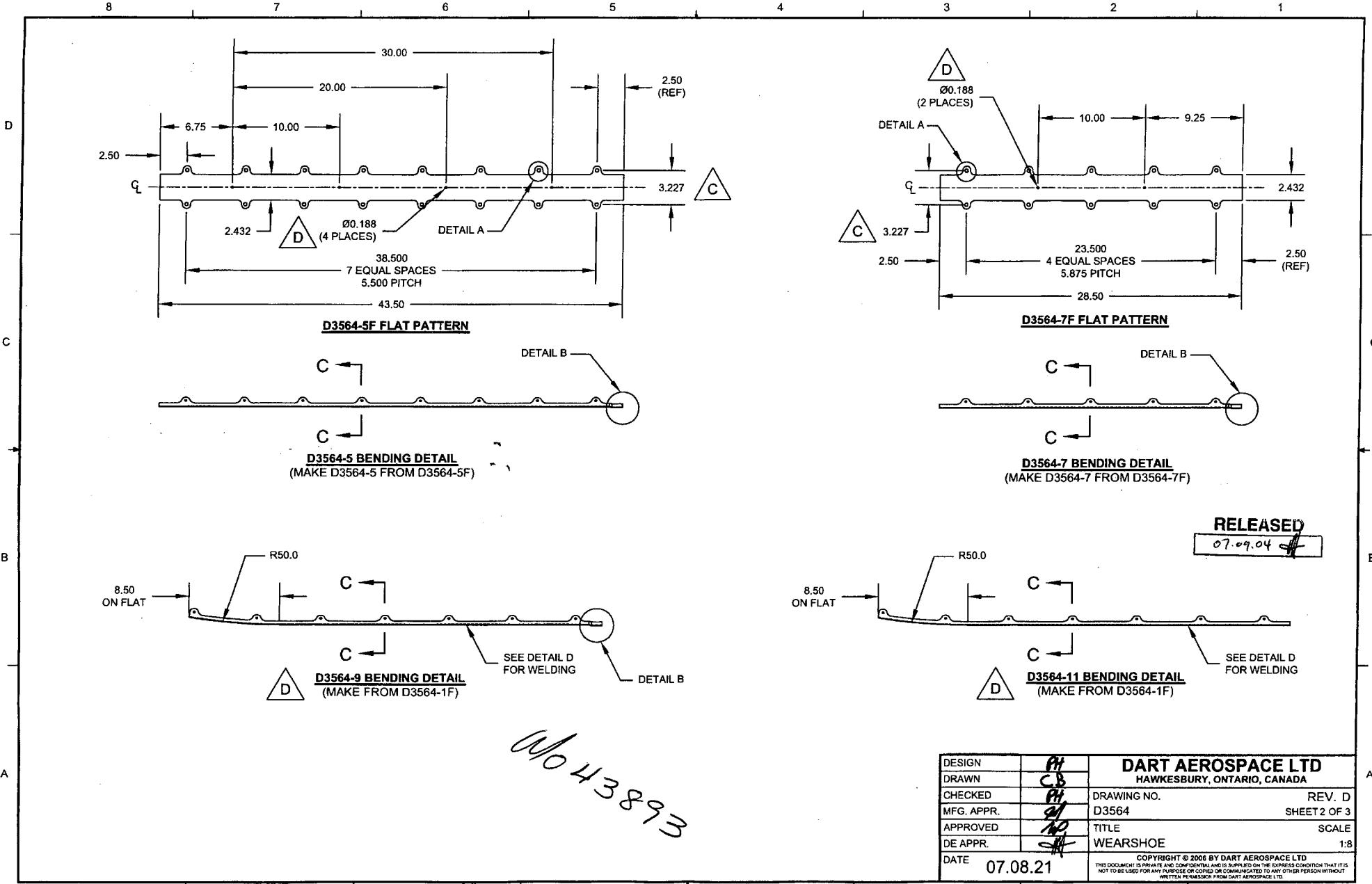
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

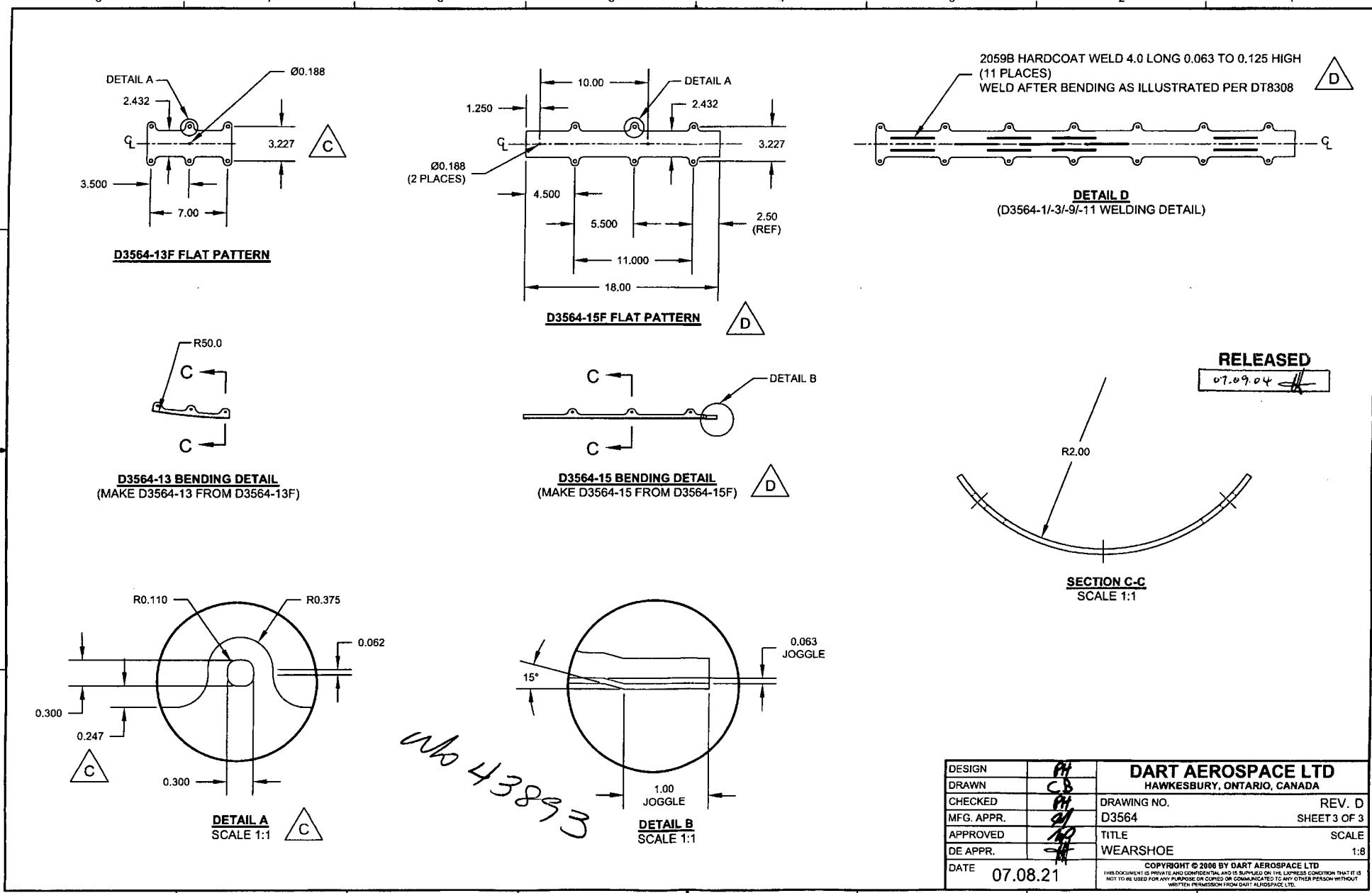


mf 08-12-09





DESIGN	<u>PH</u>	DART AEROSPACE LTD	
DRAWN	<u>CB</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>PH</u>	DRAWING NO.	REV. D
MFG. APPR.	<u>SI</u>	D3564	SHEET 2 OF 3
APPROVED	<u>AD</u>	TITLE	SCALE
DE APPR.	<u>SH</u>	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	



DART AEROSPACE LTD

Work Order: 43893

Description: WEAR SHOE

Part Number: D 3564-5

Inspection Dwg: D3564-5, Rev: 0

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:

12

Audited by:

Prototype Approval:

Date -

8-12-3

Date: 08/12/04

Date:

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	